

Work Order ID 55430

January 18, 2010 1:07:44 PM

Page 1

Item ID: D6103-003

Accept

Setup Start

Revision ID:

Stop

Item Name: Round Billet, Aluminum

Start Date: 1/18/10 Start Qty: 40.00

Cust Item ID:

Required Date: 1/21/10 Req'd Qty: 40.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-1-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6103

Rev B

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 11160 a) Description: Aluminum round billet, b)
Ø3.500" x 12.500" long c) Tolerance on all dimensions are +0.030"/-0.000"
d) Material: 7075-T7351 (QQ-A-225/9) Material certification required

BS 10-1-18

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

PC 10/2/4 (33)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

amf 10/02/10 33

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 55430

January 18, 2010 1:07:44 PM

Page 2

Item ID: D6103-003

Accept

Setup Start

Revision ID:

Stop

Item Name: Round Billet, Aluminum

Start Date: 1/18/10 Start Qty: 40.00

Required Date: 1/21/10 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: MAT

0.00

mk 10/02/1033

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/10UMF 10-2-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

January 18, 2010 1:07:49 PM

Page 1

Work Order ID: 55430



Parent Item: D6103-003



Parent Item Name: Round Billet, Aluminum



Start Date: 1/18/10

Required Date: 1/21/10

Comments: IPP Rev:A New Issue 06-02-09 JLM

Start Qty: 40.00

Required Qty: 40.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--|---------------|----------------|--------|
| D6103-003P  round alum billet | | Purchased | No | | | 110 | Each | 0.0000 | 40.0000  | | | |

12/1/10 4 (33)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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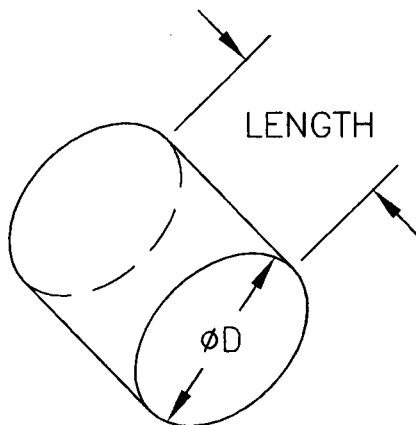
NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>P41</i> | DRAWN BY <i>P41</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D6103 | Rev. B SHEET 1 OF 1 |
| DATE 06.01.31 | | TITLE ROUND BILLET, ALUMINUM | SCALE NTS |
| A | 01.04.10 | NEW ISSUE | |
| B | 06.01.31 | ADD D6103-003 | |

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *354130*
BJ10-1-18

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

| Part No. | Alloy | D (Diameter) | Length |
|-----------|--|-----------------|--------|
| D6103-001 | 7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9) | Ø3.250 | 12.50 |
| D6103-003 | 7075-T7351 (QQ-A-225/9) | Ø3.500 | 12.50 |
| | | | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

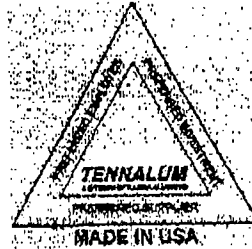
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

| | | | | | |
|---|----------------------|-------------------------------|---|---|----------------------|
| CUSTOMER PO NUMBER: 01-17386 | | CUSTOMER PART NUMBER: 8808 | | PRODUCT DESCRIPTION: Cold Finished Round | |
| KAISER ORDER NUMBER: 648879 | LINE ITEM: 1 | SHIP DATE: 01/05/2009 | ALLOY: 7075 | TEMPER: T7351 | |
| WEIGHT SHIPPED: 1967 lbs. | QUANTITY: 14 pcs. | B/L NUMBER: 28952 | DIAM/DAF/THKNS: 3.500 in. | WIDTH: 0.000 in. | LENGTH: 144.0 in. |
| SHIP TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA | | | SOLD TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA | | |

Test Code: 1000 AC

Actual Physical Properties

| Lot Number | LONG. UTS ksi | LONG. YTS ksi | LONG. ELONG. % | COND % IACS |
|------------|---------------------|---------------------|----------------------|----------------|
| 20117526 ✓ | 70.3 | 58.7 | 16.0 | 39.3 |

Chemical Composition, WT. % (Aluminum Remainder)

| | Si | Fe | Cu | Mn | Mg | Cr | Zn | Ti | OTHERS EACH | OTHERS TOTAL | Lot |
|--------|------|------|-----|------|-----|------|-----|------|----------------|-----------------|----------|
| Actual | 0.11 | 0.26 | 1.5 | 0.04 | 2.7 | 0.20 | 5.8 | 0.02 | | | 20117526 |
| Max | 0.40 | 0.50 | 2.0 | 0.30 | 2.9 | 0.28 | 6.1 | 0.20 | 0.05 | 0.15 | |
| Min | | | 1.2 | | 2.1 | 0.18 | 5.1 | | | | |

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

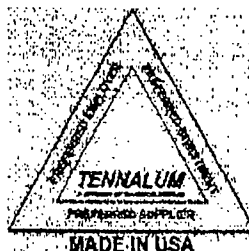
Plant Serial: 117

Kaiser Order Number: 648

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. AS9100B:2004 This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material is RoHS compliant.

CASTLE METALS CORP.
DATE RCVD 1/5/09
IAC
APPROVED BY [Signature]

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

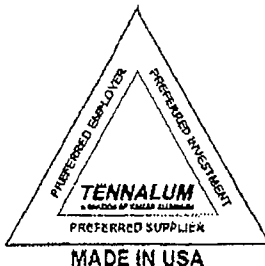
John Rennekamp, Quality Manager

Plant Serial: 117651

Kaiser Order Number: 648879

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

| | | | | | |
|--|---------------------|-------------------------------|---|---|----------------------|
| CUSTOMER PO NUMBER: 02-31665 | | CUSTOMER PART NUMBER: 8808 | | PRODUCT DESCRIPTION: Cold Finished Round | |
| KAISER ORDER NUMBER: 649109 | LINE ITEM: 1 | SHIP DATE: 02/06/2009 | ALLOY: 7075 | TEMPER: T7351 | |
| WEIGHT SHIPPED: 987 lbs. | QUANTITY: 7 pcs. | B/L NUMBER: 29084 | DIAM/DAF/THKNS: 3.500 in. | WIDTH: 0.000 in. | LENGTH: 144.0 in. |
| SHIP TO: A M Castle & Co 14001 Orange Ave Paramount, CA 90723 USA | | | SOLD TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA | | |

Test Code: 1000 AC

Actual Physical Properties

| Lot Number | LONG. UTS ksi | LONG. YTS ksi | LONG. ELONG. % | COND % IACS |
|------------|---------------------|---------------------|----------------------|----------------|
| 20117801 | 71.5 | 60.1 | 15.0 | 38.6 |

Chemical Composition, WT. % (Aluminum Remainder)

| | Si | Fe | Cu | Mn | Mg | Cr | Zn | Ti | OTHERS EACH | OTHERS TOTAL | Lot |
|--------|------|------|-----|------|-----|------|-----|------|----------------|-----------------|----------|
| Actual | 0.13 | 0.28 | 1.5 | 0.04 | 2.8 | 0.20 | 6.0 | 0.02 | | | 20117801 |
| Max | 0.40 | 0.50 | 2.0 | 0.30 | 2.9 | 0.28 | 6.1 | 0.20 | 0.05 | 0.15 | |
| Min | | | 1.2 | | 2.1 | 0.18 | 5.1 | | | | |

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

ml
10/02/10

CASTLE METALS - LA
DATE REC'D *2-17-09*
RD #/MILL *Kaiser 3324*
APPROVED BY *JP*
IAC *8808*

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

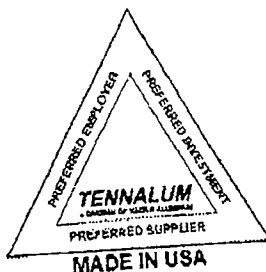
John Rennekamp

Plant Serial: 119239

Kaiser Order Number: 649109

KAISER
ALUMINUM
FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

Miscellaneous Notes

Made in USA
This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material complies with FAR BAA (FAR 52.225-1, Buy American Act-Supplies), DFARS BAA (DFARS 252.225-7001 Buy American Act & Bal of Payments Prog), and FAR TAA (FAR 52.225-5 Trade Agreements) AS9100B:2004 Material is RoHS compliant.

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 119239
Kaiser Order Number: 649109
Line Item: 1



Castle Metals®

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Pack Slip No:182813

| | | | | | | | |
|---|-------------------------|--|---------------------------------------|--|--------------------------------|--------------------|--|
| Ship From: Castle Metals Los Angeles 14001 Orange Avenue Paramount, CA 90723 | | Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 | | Ship To: CASTLE METALS-MONTREAL LABOR BUY ACCOUNT SHIP TO VENDOR FOR LABOR POINTE CLAIRE, QC H9R 3S2 | | Deliver To: | |
| Date Shipped 22-JAN-10 | F.O.B. ORIGIN | Freight Terms Prepaid | Carrier CASTLE_NETWORK K | BOL No 183936 | Delivery No 14052294 | | |

| | |
|-------------------------|-----------------------------------|
| Shipment Details | Final Destination Branch - |
|-------------------------|-----------------------------------|

| | | | | | | |
|-----------------------------------|------------------------------|---------------------------|--|------------------------------|----------------------|--------------------------|
| Order No 515862 | Line No 1 | Item No 8808.MO | Description 3.5000.RD.7075.T7351.ALUMINUM.CF.132.0000-144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 4124,AMS QQ-A-225/9,ASTM B211 | | | |
| Purchase Order No 11160 | | Part Number | Ordered Qty 33 PCS | Invoice Qty 33 PCS | Backorder Qty | |
| Details | | | | | | |
| Mill | Heat Number | Mech ID | PCS | Width (IN) | Length (IN) | Shipped Qty (LBS) |
| KAISER ALUMINUM | 20117801 - | 2-3-70 | 22 | | | 266.76 |
| KAISER ALUMINUM | 20117801 - | | 4 | | | 48.5 |
| KAISER ALUMINUM | 20117801 20117526 | | 7 | | | 84.88 |

| | |
|---|-------|
| These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited. | |
| We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit. | |
| This material has been received and inspected by: | Date: |



Chantal Lavoie

From: Camilli, Tracy [tcamilli@amcastle.com]
Sent: February 10, 2010 10:42 AM
To: clavoie@dartaero.com
Cc: Desbiens, Marc; Boucher, Christiane
Subject: FW: Certs/ packing slip # 182813
Importance: High
Attachments: Castle Metal.jpg; Castle Metal-2.jpg; Castle Metal-3.jpg

Please be advised that what you see as the quantity on the Kaiser Cert doesn't reflect your order- this information provided lies with Castle's " at time " receiving.

Thank you,
Tracy Camilli
Administration x 52239
Métaux Castle/ Castle Metals
T/D: 514-693-8189
F: 514-695-3281

From: Chantal Lavoie [mailto:clavoie@dartaero.com]
Sent: Wednesday, February 10, 2010 7:22 AM
To: Camilli, Tracy
Subject: Certs/ packing slip # 182813
Importance: High

Please find attach copies of certs and packing slip.
The qty and heat # doesn't match! As per our quality control inspector, everything should be the same!!
Thank You

This E-mail may contain proprietary information and may be confidential. You are to treat this material in accordance with your company's confidentiality policies and limit any distribution accordingly. If you are not the intended recipient of this E-mail, you are hereby notified that any dissemination, distribution or copying of this message is strictly prohibited. If you received this message in error, please delete it immediately.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries